

Date: Tuesday, 5/23/2006 8:36:15 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG  
 Job Number : 27204  
 Estimate Number : 10318  
 P.O. Number : N/A Part Number : D2659  
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D2659 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : A  
 Previous Run : 26786 Material : N/A  
 Written By : See Comment Below Due Date : 6/10/2006 Qty: 30 Um: Each  
 Checked & Approved By : 06-05-23  
 Comment : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 27204A LUG



Comment: Sub-Component LUG

2.0 27204B LUG BRACKET



Comment: Sub-Component LUG BRACKET

3.0 D2657 Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2657	Lug	B27204 A

PD

06-07-31

(30)

4.0 D2658 Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
1	D2658	Lug Bracket	B27204 B

PD

06-07-31

(30)

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484

A/R Steel Rod M18579

PD

06-07-31

(30)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/08/04

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 8:36:15 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 27204

Part Number: D2659

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/07/24 (30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.m 06-08-02

(30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PL 6/8/03 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST/41

L.D. LB 08/08/03

(30)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/04 (30)

Job Completion



C206/08/04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

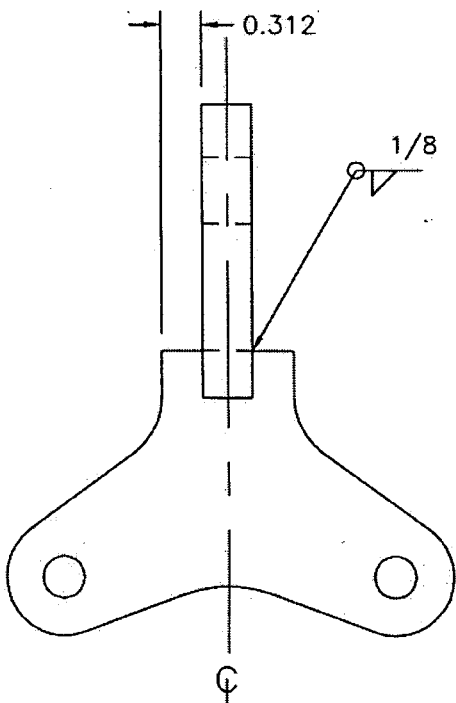
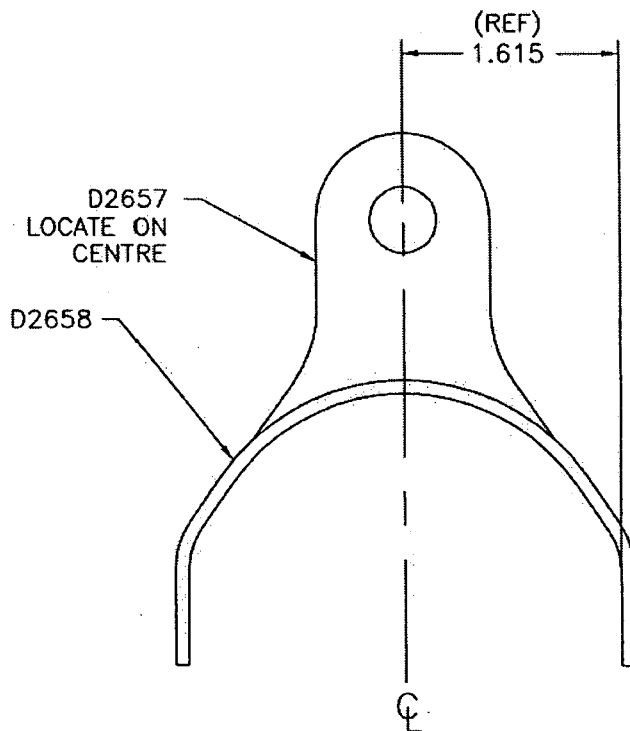
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**



DESIGN	DRAWN BY	REV. A
CHECKED	APPROVED	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
DATE	DRAWING NO.	SHEET 1 OF 1
97.11.03	D2659	SCALE
	TITLE	NIS
A	97.11.03	LUG ASSEMBLY
		NEW ISSUE

RELEASED  
47/11/06 DS



D2659 LUG ASSEMBLY

WELD PER DART QSI 004  
FINISH: POWDER COAT PER DART QSI 005 4.4  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
PART IS SYMMETRIC ABOUT CENTRE-LINES (C)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27204

Date: Friday, 7/28/2006 9:28:41 AM  
 User: Eric Charbonneau

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY 206L/407 GHW LUG
Job Number : 27204	
Estimate Number : 10318	
P.O. Number :	Part Number : D2659
This Issue : 7/28/2006 S.O. No. :	Drawing Number : D2659 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 5/23/2006 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 26786	Material :
Written By :	Due Date : 6/10/2006 Qty: 30 Um: Each
Checked & Approved By :	
Comment : Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	27204A	LUG
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Comment: Sub-Component LUG

2.0	27204B	LUG BRACKET
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Comment: Sub-Component LUG BRACKET

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  
 LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2659 using location Jig DT8484  
 A/RSteel Rod \_\_\_\_\_

4.0	QC5/9	WELD INSPECTION
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs  
 WELD INSPECTION

5.0	POWDER COATING	POWDER COATING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

POWDER COATING  
 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-08-02

(30)



Date: Friday, 7/28/2006 9:28:41 AM  
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Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 27204

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

DOCUMENT CONTROL

Inspection Level 21

Job Completion

